



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D4273-042
Job Sheet 171443



Part No: D4273-042

Job Qty: 1 ea

Part Name: Basket Base Assembly, RH



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 2/1/18

Job Tracking No:

Due Date: 2/16/18

Created By: Linda Lacelle

Type: SOLD

Description:

Note: DWG D4279 REV B SHEETS 1,2, D4273 REV F SHEETS 6,7,8,9,10 IPP Rev:A 10.11.16 new issue DD
verf:EC IPP Rev:B 11.01.20 AS PER DWG REV.C DD verf:EC IPP Rev:C 11.03.03 AS PER DWG REV.D DD
verf:EC IPP REV:D 12.07.24 AS PER DWG REV.E DD VERF:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		2/14/18	0.00	0.00	Start Up Large Fab-6		D.M.L 18-2-13
100	Large Fab	1 pcs		2/15/18	0.00	31.15	Large Fab 1		SM 18-2-13
110	QC	1 pcs		2/15/18	0.00	0.00	QC9		CPC
120	QC	1 pcs		2/15/18	0.00	0.00	QC5		CPC
125	HandFinish	1 pcs		2/15/18	0.00	0.40	HandFinish2		358 18-02-14
130	Powdercoat	1 pcs		2/16/18	0.00	0.67	Powdercoat2		BL 18-02-14
140	QC	1 pcs		2/16/18	0.00	0.00	QC3		W 18-2-13
150	Packaging	1 pcs		2/16/18	0.00	0.00	Packaging3-2		168 18-2-13
160	QC21-SA	1 Ea		2/16/18	0.00	0.00	QC21		21 FEB 15 2018

Part Op 100 - 1- assemble ribs and handle plates (DO NOT WELD HANDLE IN SECTION N-N ON PAGE 7 DWG D4273, NEED Descriptions: TO WELDED AFTHET MESH IS INSTALL) weld as per dwg D4273 using DT10317 2- Cut D4279-1 (MADE ON THIS W/O) base mesh and tack weld all mesh on basket as per dwg D4273 and trim mesh to fit if necessary and trim to clear fasteners holes on the ends (D4279-5/-9)

130 - 1- Plug holes and mask only interior of hinge (3) prior to powder coat

M138467 START: 3:40. O.V.T: 375° FINISH: 3:55.

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :	Step #:	QTY Effective :				MRB (QSI042) Approval	
Description Work Order Deviation		Disposition				Completed By	
						Lead hand / Supervisor Approval Verification	
						QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY					
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐	OTHER : ☐	

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2581	Mounting Bracket	2 Ea (2 ea)	90-Start up Operation	5033557 5033599
D3913-1	Rib	1 Ea (1 ea)	90-Start up Operation	5032741
D3913-15	Wide Handle Plate	1 Ea (1 ea)	90-Start up Operation	5034377
D3913-3	Rib	1 Ea (1 ea)	90-Start up Operation	5032655
D3913-9	Hinge Rib	1 Ea (1 ea)	90-Start up Operation	5030824
D3916-5	Light Rib	3 Ea (3 ea)	90-Start up Operation	5037859
D4016-1	Hinge Half, Base	3 Ea (3 ea)	90-Start up Operation	5036080(6) 5034748
D4017-7	Rib	3 Ea (3 ea)	90-Start up Operation	5031312
D4021-1	Handle Plate	3 Ea (3 ea)	90-Start up Operation	5039317
D4277-19	Rib	1 Ea (1 ea)	90-Start up Operation	5015631
D4277-3	Rib	1 Ea (1 ea)	90-Start up Operation	5015591
D4277-5	Rib	2 Ea (2 ea)	90-Start up Operation	5015962
D4277-9	Rib	1 Ea (1 ea)	90-Start up Operation	5015811
D4278-041	Upper Rib Assembly-Hoop	1 Ea (1 ea)	90-Start up Operation	5017978
D4278-045	Rib Assembly, Fwd Cham	2 Ea (2 ea)	90-Start up Operation	5018917(6) 501234
D4278-047	Upper Rib Assembly-Straight	1 Ea (1 ea)	90-Start up Operation	5017734
D4279-5	End Mesh, Basket	1 Ea (1 ea)	90-Start up Operation	50058162
D4279-7	End Mesh, Basket	2 Ea (2 ea)	90-Start up Operation	5005859(16)
D4279-9	End Mesh, Basket	1 Ea (1 ea)	90-Start up Operation	5024968
D4306-044	Rib Assembly, RH	1 Ea (1 ea)	90-Start up Operation	5019694
D4306-045	Rib Assembly	1 Ea (1 ea)	90-Start up Operation	5018911
D4306-1	Rib	1 Ea (1 ea)	90-Start up Operation	5032831
D4672-1	Blanking Plate	2 Ea (2 ea)	90-Start up Operation	5036909
M304EX0.75-16F	Expanded Metal Flat SS	32 sf (32 ea)	90-Start up Operation	5029997

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D2581	2	80	0
	D3913-1	1	7	0
	D3913-15	1	22	0
	D3913-3	1	10	0
	D3913-9	1	9	0
	D3916-5	3	19	0
	D4016-1	3	86	0
	D4017-7	3	72	0
	D4021-1	3	7	0
	D4277-19	1	3	0
	D4277-3	1	4	0
	D4277-5	2	12	0
	D4277-9	1	2	0
	D4278-041	1	6	0
	D4278-045	2	4	0
	D4278-047	1	5	0
	D4279-5	1	6	0
	D4279-7	2	0	0
	D4279-9	1	6	0
	D4306-044	1	8	0
	D4306-045	1	6	0
	D4306-1	1	10	0
	D4672-1	2	56	0
	M304EX0.75-16F	32	669	0

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____		DISPOSITION		AGAINST DEPARTMENT/PROCESS	
Part No. _____		Dart Aerospace Ltd. 1270 Aberdeen Street Hawkesbury, ON K6A 1K7 CANADA TEL: 1 613 632-5200 Email: sales@dartaero.com www.dartaerospace.com		Loss tube ☐ Water Jet ☐ Engineering ☐ Small Fab ☐ Prod. Eng. Coord. ☐ Quality ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐ Composite ☐ Supplier ☐	
NCR No. _____				MRB (QSI042) Approval _____ Disposition _____	
Date: _____					
Step _____ Fork Or _____		Completed By _____ Lead hand / Supervisor Approval Verification _____ QC / QA Coordinator Approval _____			
Master Unit 000590 Job No 171443 DART AEROSPACE S041778 Basket Base Assembly, RH					
PART NO: D4273-042 Original Serial #: S041778 Revision: Operation: Change No: Start up Operation 02/13/18 Job No: 171443					
Envir _____ D. _____ Equip/ _____ Handling _____ Material _____ Internal Transport _____ Tribal Knowledge _____ LOA _____ Substation _____ Past Expiry Date _____ Misidentified _____		CATEGORY ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence			
Training _____ Use for Testing _____ Poor Information _____ Rushing _____ Product Improvement _____ Process Improvement _____ Manufacturing Process _____ Past Due _____		OTHER: _____			